

Date: Monday, 19/11/2007 1:43:29 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 35894
 Estimate Number : 10804
 P.O. Number : *NA*
 This Issue : 19/11/2007 S.O. No. : *NA*
 Prsht Rev. : *NC*
 First Issue : *NA* Type : LANDING GEAR
 Previous Run : 35515
 Written By : *h*
 Checked & Approved By : *h*
 Comment :

Drawing Name : D206-667-101A
 Part Number : D206667101A
 Drawing Number : REWORK-ARM SHIELD
 Project Number : *NA*
 Drawing Revision : *NA*
 Material : *NA*
 Due Date : 26/11/2007 Qty: 1 Um: Each

Additional Product

Job Number:



DART		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL 09-89			
PN	D206-667-101A	CHG	CHG001
DESC	Crosstube Fwd High	STC	SH01-5
LOT	B33499	STC	SR01304NY
MODEL	Bell 206A/B	STC	
MADE IN CANADA			

Seq. #: Machine Or Operation:

Description :

1.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

REMOVE FROM STOCK:

1 X D206-667-101A B33499

STRIP P746 ARMOR SHIELD

*ml 07 11 24**①*

2.0

D206667101A

Crosstube Installation W/ armour shield



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Crosstube Installation W/ armour shield

3.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

RE-SPARY PAINT CROSSTUBE

WHITE IMRON PER QSI 005 4.2

APPLY NEW ARMOR SHIELD
PER QSI 9326 REV.B*h paint only - no armor shield**ml 07 11 25 ①*

4.0

QC14

INSPECT SPRAY PAINT


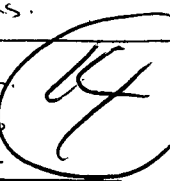
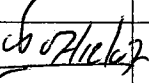


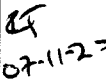





Comment: INSPECT SPRAY PAINT

21 07 11 26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D206-667-1012 PAR #: N/A Fault Category: Prod / Finishing NCR: Yes No DQA: W Date: 07/12/13
 QA: N/C Closed: W Date: 07/12/13

NCR: <u>35894</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/28	4 C10	During Paint inspection the nut plate D2873-005 was installed incorrectly. P.C. Human error		Drill out Rivets. Reinstall / Rerew. L. MS20601AD C1008 B# 105057	 07/11/27	 07/12/07	 05/24/12	 07.11.28
				Touch up Rivet heads with white Zinnon Paint as per Q57-005	 07/11/27	 07/12/07		
				*Refer to w/o # 29099 when work was completed				

NOTE: Date & initial all entries

Date: Monday, 19/11/2007 1:43:29 PM
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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-667-101A

Job Number: 35894

Part Number: D206667101A

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
REASSEMBLE PER DRWG D206-667-243
USING EXISTING HARDWARE
RECORD ANY NEW HARDWARE:

abrasion strip B34642

07-11-27

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 A1267 (40)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP
ENSURE ORIGINAL KIT IS IN BOX.

Rev

A

7/12/07 SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20/12/11

Job Completion



20/12/11

20/12/11

DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment. To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. The Change Number of Dart crosstubes with "Armor Shield" is affected as per above table. It is acceptable to apply the Armor Shield in regions shown in Figure 1 or Figure 2 only. It is **NOT** acceptable to apply Armor Shield in the cuff and support/clamp regions.

INSTALLATION	STC		CHANGE NUMBER	
	CANADIAN	FAA	DSI 9326 REV. A (Proform PF746/746-1 Treatment)	DSI 9326 REV. B (BCG4 Treatment)
D205-596-101A/-103A/-105/-107A	SH03-6 ISSUE 3	SR01742NY	CHG 001	CHG 002 (or later)
D212-664-101A/-201A D412-664-203A D412-664-105A/-205A	SH01-9 ISSUE 3	SR01298NY	CHG 002 (or earlier) CHG 004 (or earlier) N/A	CHG 003 (or later) CHG 005 (or later) CHG 001 (or later)
D206-667-101A/-103A/-201A/-203A D407-667-105A/-205A	SH01-5 ISSUE 3	SR01304NY	CHG 001 CHG 002 (or earlier)	CHG 002 (or later) CHG 003 (or later)
D058-676-101A/-201A	N/A	SR01018SE	CHG 001	CHG 002 (or later)
D350-748-101A/-201A	SH06-27 ISSUE 1	SR02359NY	N/A	CHG 001 (or later)

1.0 TO APPLY ARMOR SHIELD







- 1.1 Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 1.2 Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area
- 1.3 Mask areas around supports and cuffs per Figure 1 or Figure 2 (D350-748-101/-201 only). Abrade paint finish in areas requiring protection using 800 grit sandpaper. Ensure the surface is de-glossed.
- 1.4 Re-clean the surface per Step 1.2.
- 1.5 Mix BCG4 Component A and BCG4 Component B in accordance with manufacturer's instructions.
- 1.6 Apply 5 wet coats in accordance with manufacturer's instructions.
- 1.7 To avoid hard tape line, unmask immediately after application of last coat.
- 1.8 Allow BCG4 to dry in accordance with manufacturer's instructions.

2.0 ARMOR SHIELD REMOVAL / RE-APPLICATION

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 2.1 Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2.2 Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 2.3 Apply Armor Shield in accordance with Section 1.0 of these instructions.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01 APPROVED  BY: <u>D. SHEPHERD (DE # 02)</u> DATE: <u>07.10.17</u> CERT. NO.: <u>SEE TABLE</u> ISSUE NO.: <u>SEE TABLE</u>

B	BCG4 REPLACES DISCONTINUED PROFORM PF 746 OR PF 746-1; ADD D350-748-101/-201	MB	07.10.17
A	NEW ISSUE	PH	06.02.14
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. B DSI 9326 SHEET 1 OF 2 TITLE SCALE ARMOR SHIELD NTS	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.17		
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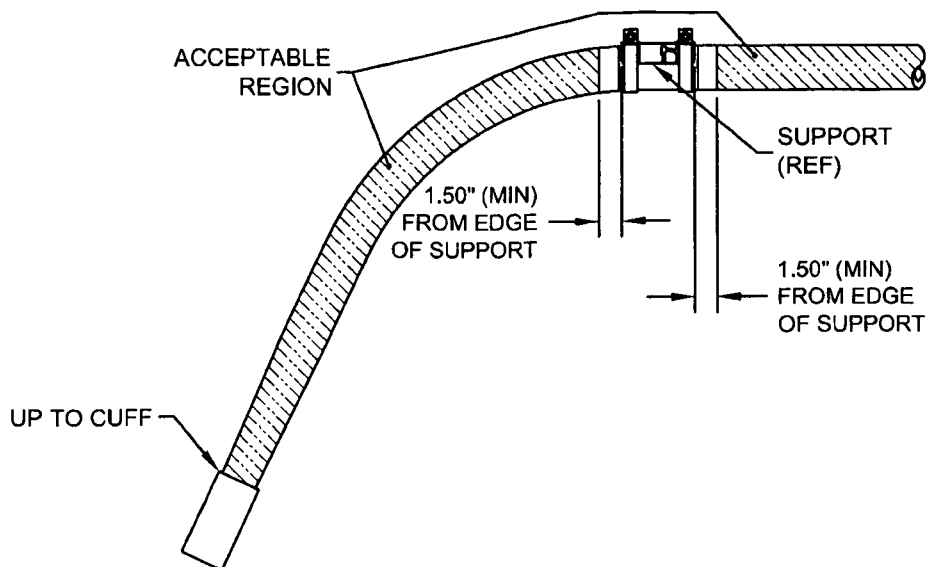


FIGURE 1 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD
(SEE FIGURE 2 FOR D350-748-101/-201 CROSSTUBES)

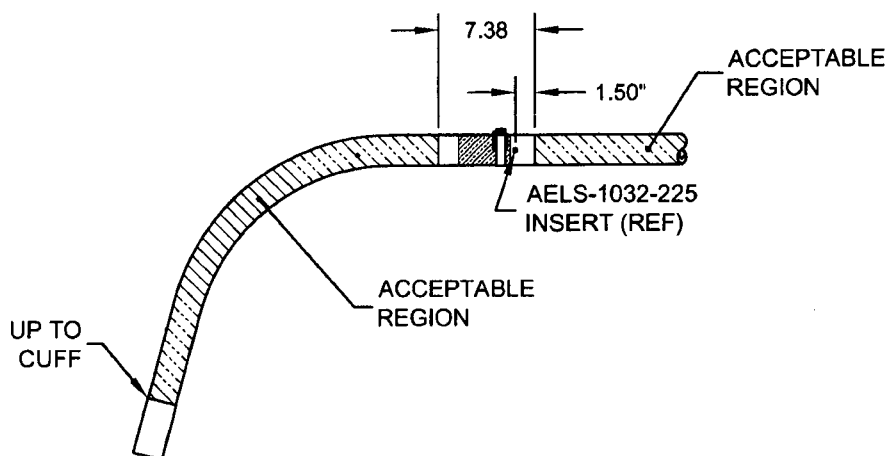


FIGURE 2 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD
(D350-748-101/-201 ONLY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 07.10.17
CERT. NO.: SEE TABLE
ISSUE NO.: SEE TABLE

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	EG	DSI 9326	SHEET 2 OF 2
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	ARMOR SHIELD	NTS
DATE	07.10.17	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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**Commercial Invoice: 201**

Ship From: Offshore Helicopters
200 A Burgess Drive
Broussard LA 70518
USA
Tad Kling

IRS# 721413256
TEL: 337 829 0500

Ship To: Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Linda Iacelle
613 632 5200

Date: 7-Nov-07

P.O. #: Return

Ship Via: Bax Global

FOB: Exworks Origin

Refrence:

Item	Part Number / Product Description	Tariff Class.	Quantity	Unit Price	Total
1	D205-667-101A Crosstubes 334969	8803.20	1	\$ 1,000.00	\$ 1,000.00
2	D205-667-201A Crosstubes 33501	8803.20	1	\$ 1,000.00	\$ 1,000.00
3					
4					
5					

transferred back to Dart stock 02-11-17
TRF00000035

All Prices are in US Dollars
THIS IS A CUSTOMS INVOICE ONLY

Sub Total \$2,000.00

Total \$2,000.00

Amount Due: \$2,000.00

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Tel.: 1.613.632.5200
Fax: 1.613.632.1185

1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7

Transfer Slip

Page
1

Transfer Number
TRF0000035

Transfer From:

MAIN

OFFS01

Description	Amount	Account
...

Required By
Nov 19, 2007

Item Number	Description	Quantity Transferred	UOM	Quantity Received
D206-667-101A	Crosstube Installation W/ armour shield	1.0000	Each	
D206-667-201A	Crosstube Installation W/ armour shield	1.0000	Each	

Comments:

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-141	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206B HIGH FWD)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26

WJD 35894

UNDER REVIEW

06.08.10 PH

re.dwg detail F

new only

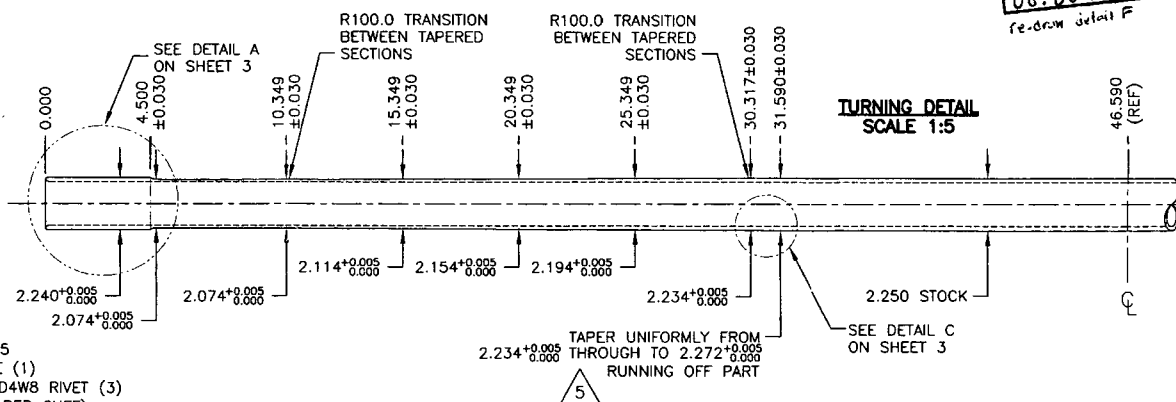
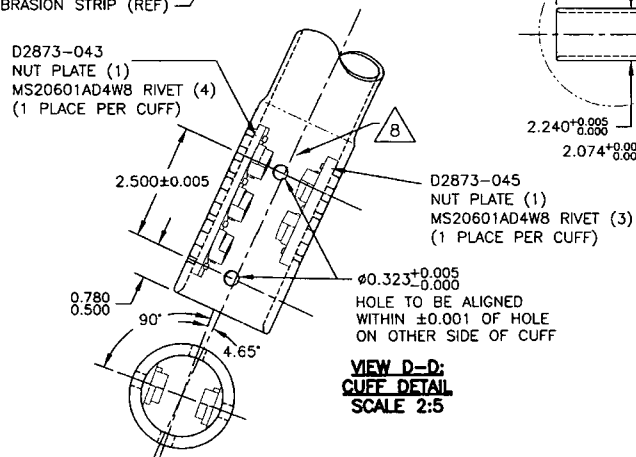
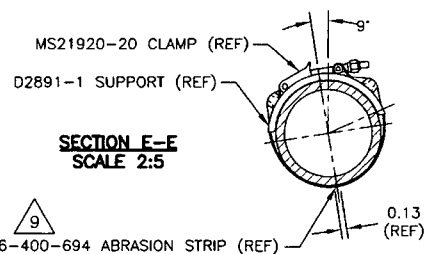
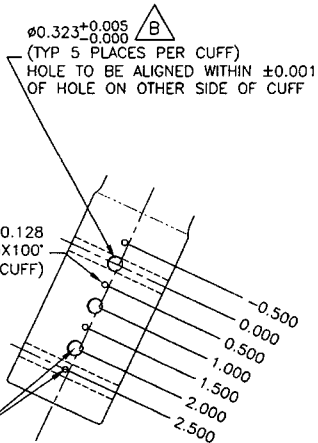
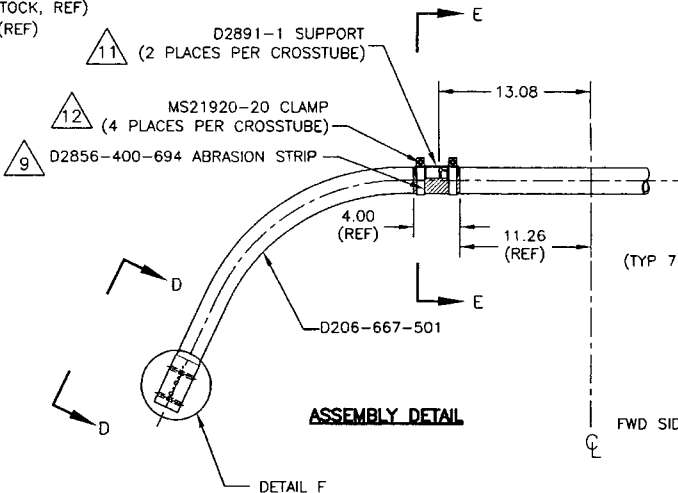
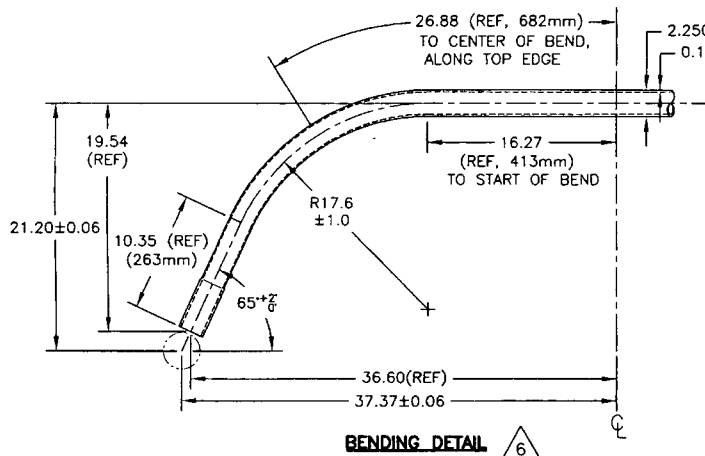
Qty	Part Number	Description
X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
1	D6001-105	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 93.18 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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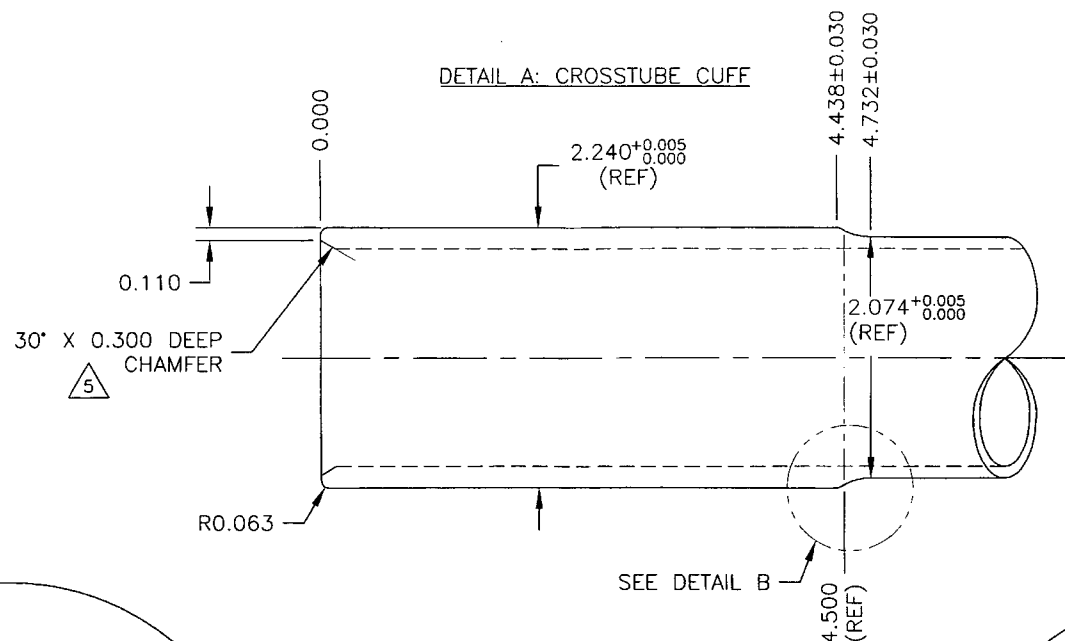


UNDER REVIEW

06.08.10 PM

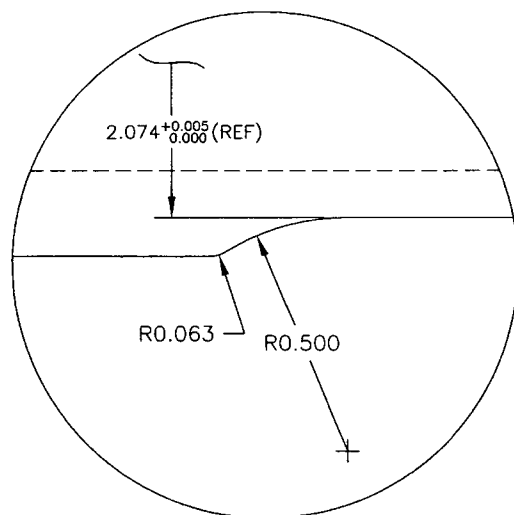
re-draw detail F

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CHECKED		APPROVED		DRAWING NO.	REV. B
DATE				D206-667-141	SHEET 2 OF 3
05.07.26				TITLE	SCALE
				CROSSTUBE ASS'Y (206B HIGH FWD)	1:10

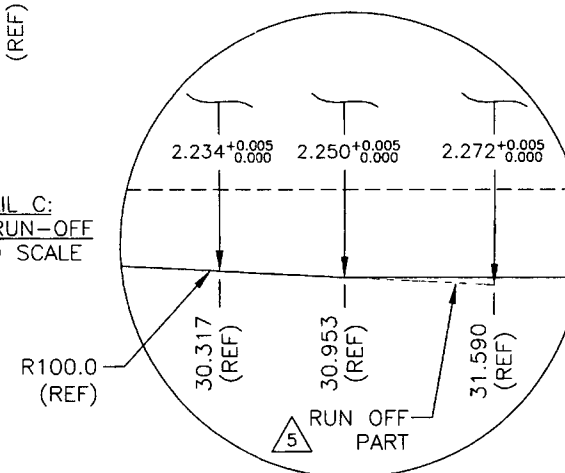


UNDER REVIEW
06.08.10 PH
re-draw detail F

05.07.26



DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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CHECKED		PH	PH	DRAWING NO.	REV. B
DATE		PH	PH	D206-667-141	SHEET 3 OF 3
05.07.26		CROSSTUBE ASS'Y (206B HIGH FWD)		SCALE 1:1	